

Work Order ID 72031

Monday, July 18, 2011 9:58:02 AM



Page 1

Item ID: D3443-043

Accept



Setup

Start



Revision ID:

Item Name: Strut Weldment Assembly

Stop



Start Date: 7/18/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11-07-11

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3443	Rev C

100



Large Fab

0.00

CL 11-08-17 (X4)

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3443

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PC 11-08-17 _____

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S 11-08-17

(X4) _____

W/O:		WORK ORDER CHANGES					
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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

Powder Coating

MW17746 400062

Memo 1-Mask holes as per dwg D3443 START TIME: *9:30*
 OVEN TEMPERATURE: *400* FINISH
TIME: 10:00

4X Ø M 11/08/19

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

4 4 11/08/19

150



Packaging

Packaging

Identify as per dwg & Stock Location *6A*

0.00

Memo

w/o 71989 (2)
w/o 71987 (2)

E5/108/22 ⑧

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/18/2011
QC

11/18/2011
4

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Picklist Print

Page 1

Monday, July 18, 2011 9:58:09 AM

Work Order ID: 72031



Parent Item: D3443-043



Parent Item Name: Strut Weldment Assembly

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3443-3 		Manufactured	No			100	Each	3.0000	1	4		<i>EL 11-8-16</i>	

Clevis

71895 X 1

Location	Loc Qty	Loc Code
WA022	3	
69055	3	

D3443-7



Manufactured No

Loc Qty	Loc Code
100	

Tubing

EL 11-8-16

Location	Loc Qty	Loc Code
WA	1	
70595	1	
WA023	3	
69056	3	

D3966-4-750



Manufactured No

Loc Qty	Loc Code
100	

Pin, Dowel

EL 11-8-16

Location	Loc Qty	Loc Code
ST100	32	
58711	32	

4

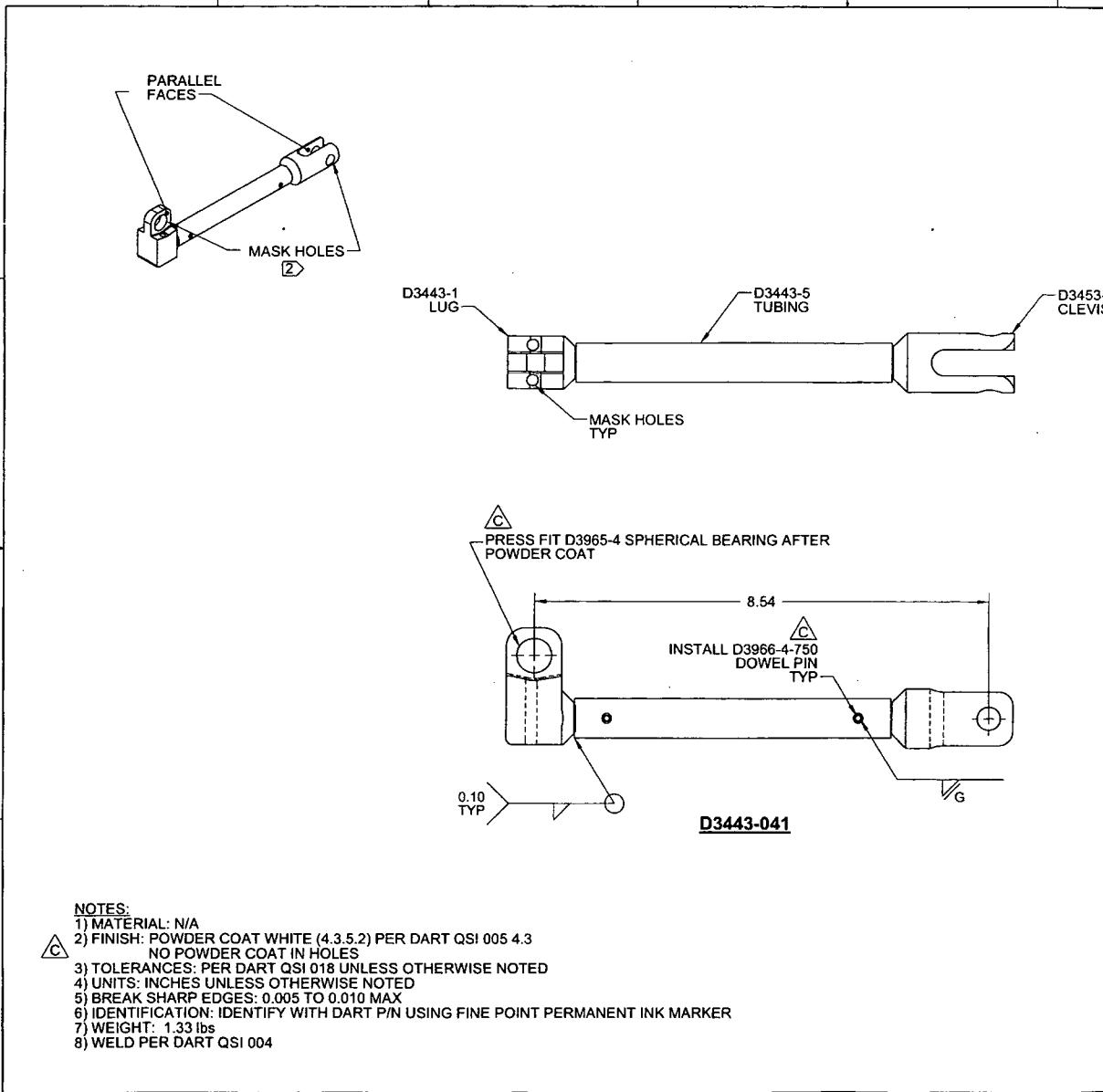
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMNT
WITHOUT NOTICE
WORK ORDER
NO. *72063*

PL11-07-16

RELEASED
gl08/SM

C	DRAWING UPDATED TO CURRENT STANDARDS. REMOVED NOTCH (D3443-1) AS PER QSI 005 4.3. ADDED -9 PIN, REMOVED BALL PLUNGER, REVISE TOLERANCE; & Ø0.125 WAS #30	RF	09.06.25
B	ADDED -9 PIN, REMOVED BALL PLUNGER, REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION		
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JL</i>	DRAWING NO.	
MFG. APPR.	<i>JL</i>	REV. C D3443	
APPROVED	<i>JL</i>	SHEET 1 OF 4	
DE APPR.	<i>JL</i>	TITLE STRUT WELDMENT ASSEMBLY	
DATE	09.06.25	SCALE NTS	

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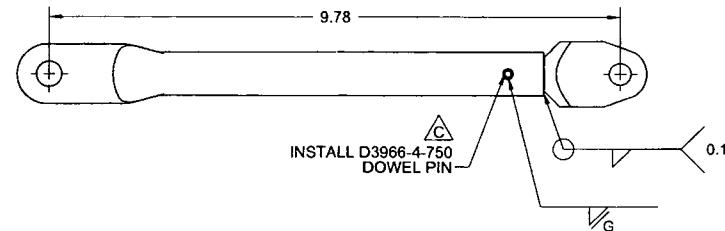
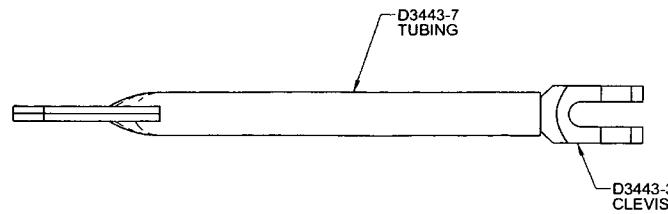
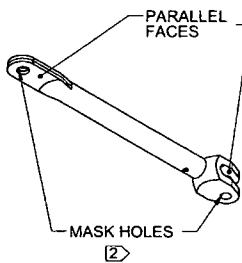
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



RELEASED
09/06/25/M

D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>UJ</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3443 SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY
DATE	09.06.25	NTS

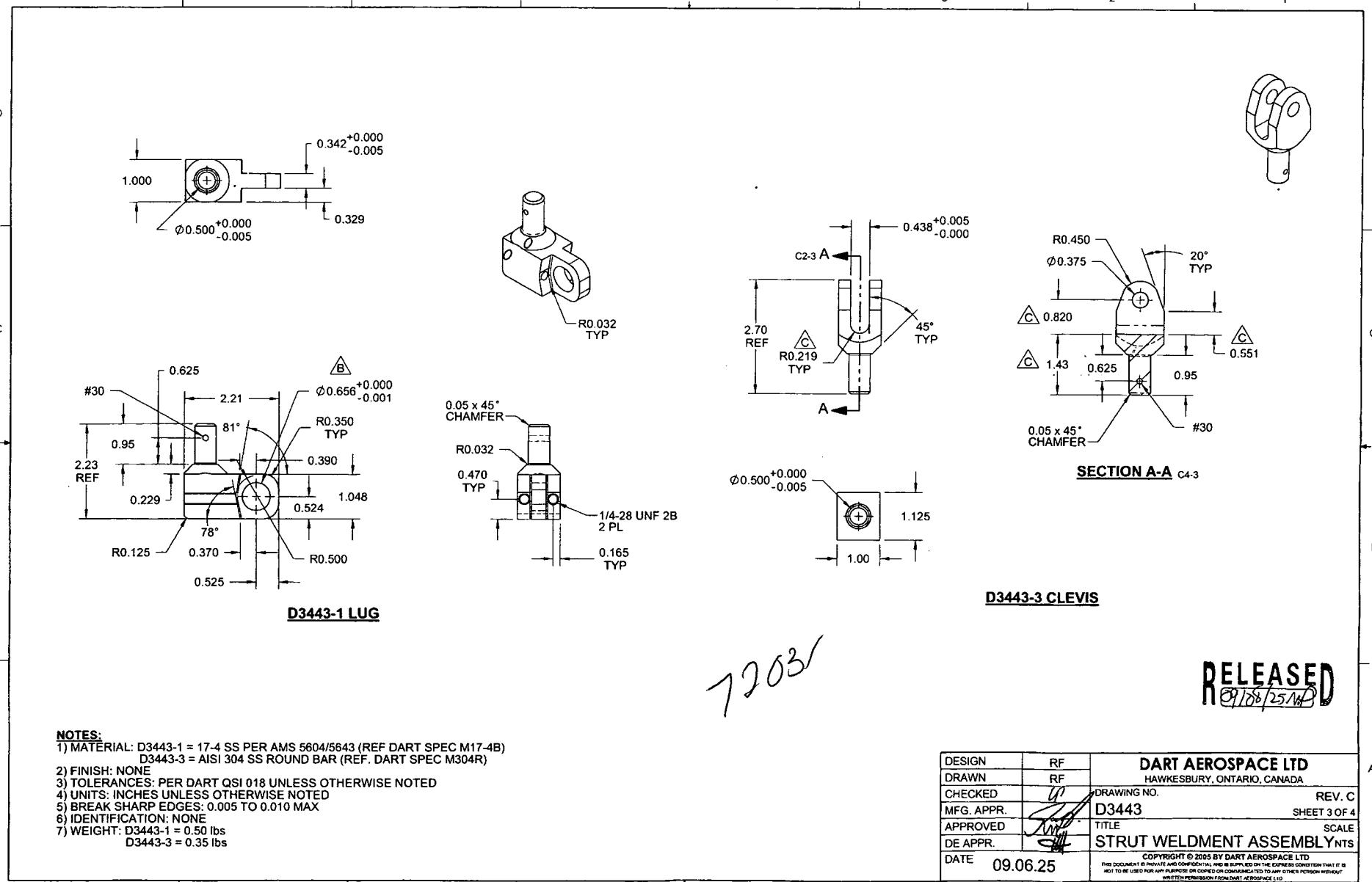
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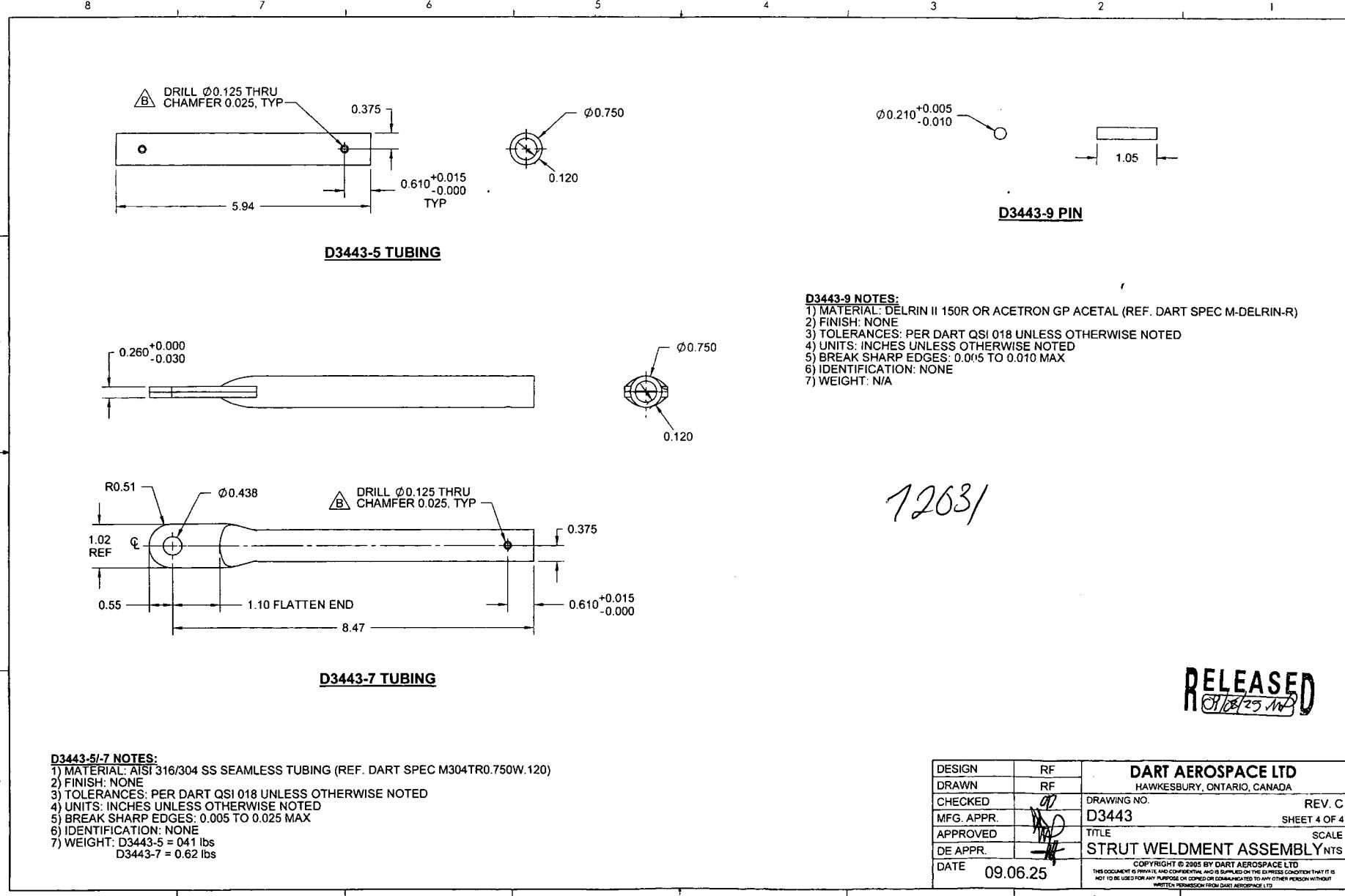
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